

# Work Order ID 79396

**\*79396\***

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January-25-12 1:03:22 PM

Item ID: D412-711-101

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Replacement Bubble Window

Start Date: 1/25/12 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 1/31/12 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D412-711-101

A

100

0.00

**\*100\***

DC

Document Control

Memo

Photocopy bluefiles and create labels for PPP D412-711-101 Change 002

0.00

5/2/11/31

for MJS 12-1-31 (4)

110

0.00

**\*110\***

HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

Set up Machine as per folio FTA 077 and D711W program using mould DT9640

0.00

x4

12/01/25

120

0.00

**\*120\***

HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

Cut Blanks to 37.5" by 43"

0.00

x4

12/01/25

**\*79396\***

January-25-12 1:03:22 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 1/25/12      **Start Qty:** 4.00      **\*4\***

**Cust Item ID:**

**Required Date:** 1/31/12      **Req'd Qty:** 4.00      **\* / \***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:**                      **Date:**                      **Tooling:**                      **Date:**

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

[illegible]

# Work Order ID 79396

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Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Bubble Window

Start Date: 1/25/12 Start Qty: 4.00 **\*4\***

Cust Item ID:

Required Date: 1/31/12 Req'd Qty: 4.00 **\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
<b>*160*</b>	HAND FINISHING THERMOFORMING					4			12/01/27
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1) Trim off excess flange material 2) Buff out any light scratches or 3) Etch part number and batch number								
170		0.00							
<b>*170*</b>	QC2- Inspect parts off machine FAI/FAIB					4			12/01/30
QC	Memo	0.00							
Quality Control	1) Visually inspect for clarity, and proper formation.								
180		0.00							
<b>*180*</b>	QC5- Inspect part completeness to step on W/O					4			
QC	Memo	0.00							
Quality Control	1) Visually inspect for clarity, and proper formation.								

**Work Order ID 79396****\*79396\***

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Required Date: 1/31/12 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
185	QC4- 100% Inspect kits for completeness	0.00							
<b>*185*</b>									
QC	Memo	0.00							
Quality Control									
190	Identify as per dwg & Stock Location: _____	0.00							
<b>*190*</b>									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
<b>*200*</b>									
QC	Memo	0.00							
Quality Control									

S 12/01/31

12/2/12

12/2/12

12/2/12

# Picklist Print

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Work Order ID: 79396

Parent Item: D412-711-101

Start Date: 1/25/12

Required Date: 1/31/12

Parent Item Name: Replacement Bubble Window

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-02-01 JLM  
10/06/28 DL

IPP Rev. B. Manufacture in-house

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.236 Plexiglass G .236"		Purchased	No				sf	280.9870		85.333333			

Location

therm

119347

Loc Qty

280.987

280.987

Loc Code

85.333333 sg ft -

12/01/30

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	79396
<b>Description:</b> Replacement Window		<b>Part Number:</b>	D412-711-101
<b>Inspection Dwg:</b> D412-711-101 <b>Rev:</b> A		<b>Page 1 of 1</b>	

**FIRST ARTICLE INSPECTION CHECKLIST**  
**THERMOFORMING SECTION**

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				

<b>Measured by:</b>	<u>DL</u>	<b>Date:</b>	12/01/25
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**TRIMMING SECTION**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	+/-0.030	2.02"	✓		Visual DL-02	
1.73	+/-0.030	1.76"	✓		Visual DL-02	
1.98	+/-0.030	2.00"	✓		Visual DL-02	
1.50	Min	1.53"	✓		Visual DL-02	
0.090	Min	0.098"	✓		ULTRA	
0.070	Min	0.095"	✓		ULTRA	
0.050	Min	0.071"	✓		ULTRA	
15.0	+/-0.5	15.1"	✓		TAPE DL-02	

<b>Measured by:</b>	<u>DL</u>	<b>Date:</b>	12/01/30
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<b>Audited by:</b>	<u>S</u>	<b>Date:</b>	12/01/25
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<b>Preliminary Approval:</b>		<b>Date:</b>	
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Rev	Date	Change	Revised by	Approved
B	10.10.08	New Issue	KJ	<u>[Signature]</u>

